

needle **1900** keel to the catheter **1902** tip. Referring now to FIG. **19B**, in some embodiments, a relief feature **1906** may be introduced into the needle **1900**. The relief feature **1900** may be introduced using one or more of, but not limited to, the following methods: machining, grinding, forging, indented, and/or etched. In some embodiments, the relief feature **1906** may smooth the transition from needle **1900** to catheter **1902** while not prohibiting the catheter **1902** to slide forward off of the introduction needle **1900** at insertion. Although one embodiment of the relief is shown and described herein, other shapes, sizes and embodiments are considered and may vary from that which is described herein.

[0123] While the principles of the invention have been described herein, it is to be understood by those skilled in the art that this description is made only by way of example and not as a limitation as to the scope of the invention. Other embodiments are contemplated within the scope of the present invention in addition to the exemplary embodiments shown and described herein. Modifications and substitutions by one of ordinary skill in the art are considered to be within the scope of the present invention.

What is claimed is:

1. An insertion device comprising:
 - a base portion;
 - a top portion slidably connected to the base portion;
 - an introduction needle; and
 - a clip connected to the top portion, wherein the clip adapted to accommodate and control a locking mechanism and wherein the clip slidably engages the locking mechanism,
 wherein as the top portion slidably advances with respect to the base portion, the clip slidably advances from the first end of the locking mechanism to the second end of the locking mechanism, whereby the locking mechanism moves from an unlocked to a locked position and whereby in the locked position, the top portion is positioned about the introduction needle.
2. The insertion device of claim 1, further comprising a flash chamber connected to the base portion.
3. The insertion device of claim 2, wherein the flash chamber further comprising an insert.
4. The insertion device of claim 3, wherein the insert is a cylindrical insert.
5. The insertion device of claim 3, wherein the insert comprising a color contrasting to the color of a flash fluid.
6. The insertion device of claim 3, wherein the insert comprising a wicking material.
7. The insertion device of claim 6, wherein the wicking material further comprising an assay test strip wherein the assay test strip indicates the presence of one or more indicators in a fluid.
8. The insertion device of claim 2, wherein the flash chamber further comprising a filter.

9. The insertion device of claim 8, wherein the filter comprising a membrane material.

10. The insertion device of claim 2, wherein the flash chamber further comprising an expandable membrane in fluid communication with the introduction needle.

11. The insertion device of claim 1, further comprising a needle guard removably connected to the base portion.

12. The insertion device of claim 2, wherein the top portion further comprising an opening to at least a portion of the flash chamber whereby the flash chamber may be viewed.

13. The insertion device of claim 1, further comprising a catheter in slidable relation to the introduction needle, wherein the catheter further comprising:

- a distal end comprising a non-perpendicular angle to the axis of the catheter and conforming to a keel of the introduction needle.

14. An insertion device comprising:

- a base portion;
- a top portion slidably connected to the base portion;
- a flash chamber, the flash chamber having an inlet and adapted for connection to an introduction needle, wherein the top portion slidably engages with the flash chamber; and
- a clip connected to the top portion, wherein the clip adapted to accommodate and control a locking mechanism and wherein the clip slidably engages the locking mechanism,

wherein as the top portion slidably advances with respect to the base portion, the clip slidably advances from the first end of the locking mechanism to the second end of the locking mechanism, whereby the locking mechanism moves from an unlocked to a locked position and whereby in the locked position, the top portion is positioned about the introduction needle.

15. The insertion device of claim 14, wherein the flash chamber further comprising an insert.

16. The insertion device of claim 15, wherein the insert is a cylindrical insert.

17. A method comprising:

- generating 2.45 GHz Radio Frequency energy using a magnetron;
- maintaining a connection between a needle and a contact;
- generating a plasma arc; and
- moving the needle into contact with the object.

18. The method of claim 17, further comprising moving the needle into contact with a die cavity for a predetermined amount of time and removing the needle from the die cavity.

19. The method of claim 17, further comprising:

- moving the needle into contact with a plastic tube;
- melting the plastic tube; and
- cooling the plastic tube wherein the plastic tube forms a seal about the needle.

* * * * *